



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14181W5-1
Job Sheet 185247



Part No: RBE105-14181W5-1

Job Qty: 5 ea

Part Name: Plunger



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W5 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		
110	Lathe Conv	5 pcs	11/9/18	11/9/18	0.00	1.25	Lathe Conv-1		
120	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		
130	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		
140	Outsource	5 pcs	11/9/18	11/9/18	0.00	0.00	Outsource13		
150	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		
190	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC6		
200	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		
210	QC21-SA	5 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. DWG REV: 2-Deburr

Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

140 - Issue P/O to GROUPE ALTECH: P/O 041722 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R1.500	1018 Round Bar 1.500	2.2150 ft (.443 ea)	90-Start up Operation	M16210

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R1.500	2	25	0

Part Specifications

s could not be found.

Plex 10/24/18 10:42 AM Dart.lajeunesse.marie



Container No: S125614



Part: RBE105-14181W5-1

Job No: 185247

Serial No/Batch: S125614

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

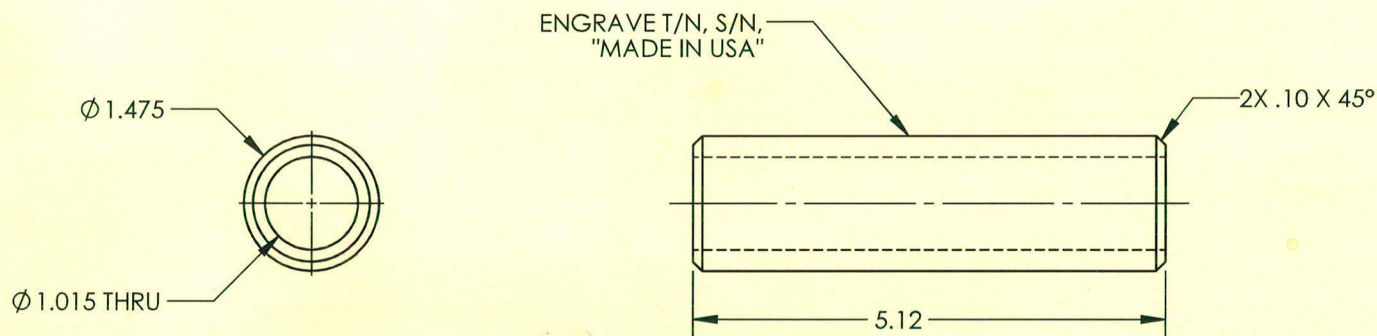
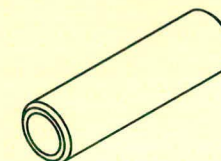
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185247 MJS
18-10-24

(-1)
PLUNGER

DART AEROSPACE	
TITLE PUSHING-OUT TOOL	
DWG NO. RBE105-14181W5-1	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:2	DATE 1/13/2016 SHEET 2 OF 7



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041722**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041722
PO Date: 11/14/18
Due Date: 11/28/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185247	RBE105-14181W5-1	Plunger -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/28/18	5 pcs	0 pcs	5 pcs	\$17.142857/pcs	\$85.71
2	185251	RBE105-14181W6-1	Plunger -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/28/18	5 pcs	0 pcs	5 pcs	\$17.142857/pcs	\$85.71
3	269T9310-3	Handle	-Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required * confirm if pick up for 27 is ok*	Firmed	-	11/27/18	4 pcs	0 pcs	4 pcs	\$17.142857/pcs	\$68.57
Grand Total:											\$240.00



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PURCHASE ORDER PO041722

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/15/18 1:45 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014452-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014452 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
20-Nov-2018		Aman		041722 ✓					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE105-14181W5-1 Rev.	RBE105-14181W5-1 ✓ 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2 MATERIAL 1018	ZINC CH	5	5 ✓	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



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						5x NOV 27 2018					DAS 68 9-89
						NOV 21 2018					error
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11/15/2018

PURCHASE ORDER



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PURCHASE ORDER
PO041722

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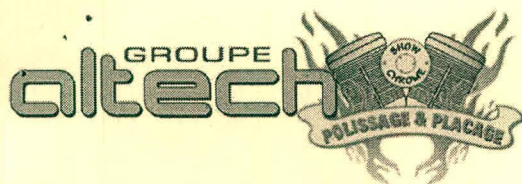
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Quality Inspector

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Received By

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88